

Work Order ID 62015

Wednesday, September 15, 2010 9:59:23 AM



Page 1

Item ID: D3571-3	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Guide					
Start Date: 9/14/2010	Start Qty: 10.00		Cust Item ID:		
Required Date: 9/21/2010	Req'd Qty: 10.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>PL</u>	Date: <u>10-9-15</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3571	Rev A								
100	BAND SAW	0.00							
	Bandsaw								
Jeaspa Bandsaw	Memo Cut blank 2.90 " long	0.00							
110	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1								
HAAS CNC vertical machine #1	Memo 1- Mill as per Folio FA681 Rev: <u>AA</u> & Dwg D3571 Rev: <u>4</u> <input type="checkbox"/> 2-Deburr per dwg D3571	0.00							
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

SL 10/10/29

10

ark 10/11/03

10

0

ark 10/11/03

10

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3571-3

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Setup Start



Revision ID:

Stop



Item Name: Guide

Start Date: 9/14/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/21/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

B-A 10/11/04



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10 BR 10-11-4.

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 1:20 OVEN TEMPERATURE:
320° FINISH TIME: 1:50

10 BR 10-11-8

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Setup Start



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Start Date: 9/14/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/21/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

=> JH 10/4/08

10 4



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 245A

0.00



Packaging

Memo

0.00

Packaging

10/11/09 (10)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 10/11/09 MF 10-11-9

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Picklist Print

Wednesday, September 15, 2010 9:59:27 AM

Page 1

Work Order ID: 62015



Parent Item: D3571-3



Parent Item Name: Guide

Start Date: 9/14/2010

Required Date: 9/21/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-01 JLM
IPP Rev:B Remove manual Machinig 08-05-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased		No		110	f	42.5606	0.241	2.536842			



6061-T6 Bar .750 X 1.50



SL 10/10/29

Location

Loc Qty

Loc Code

MAT

2.5606

114415

2.5606

MAT028

40

114968

20

114993

20

- 2.54

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42015
Description: Guide		Part Number: D3571-3
Inspection Dwg: D3571	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	.696	—		Vern	ML-7
2.75	+/-0.030	2.750	—		"	"
1.38	+/-0.030	1.373	—		"	"
1.25	+/-0.030	1.248	—		"	"
0.63	+/-0.010	.623	—		"	"
0.031 chamfer	+/-0.010	.035	—		"	"
Ø0.500	+0.006/-0.001	Ø.502	—		"	"
Ø0.201	+0.005/-0.001	Ø.202	—		"	"
R0.25	+/-0.030	R.250	—		Rad-gage	REF
0.260	+0.000/-0.010	.253	—		Vern	ML-7
Ø0.385 x 100°	+0.006/-0.001 x 0.5°	Ø.385 x 100	—		"	"
0.125	+/-0.010	.125	—		"	"
2.250	+/-0.010	2.243	—		"	"
0.250	+/-0.010	.252	—		"	"
0.188	+/-0.010	.186	—		"	"
0.063 chamfer	+/-0.010	.065	—		"	"

Measured by: [Signature]	Audited by: H.A	Prototype Approval:	N/A
Date: 10/11/03	Date: 10/11/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM [Signature]	[Signature]

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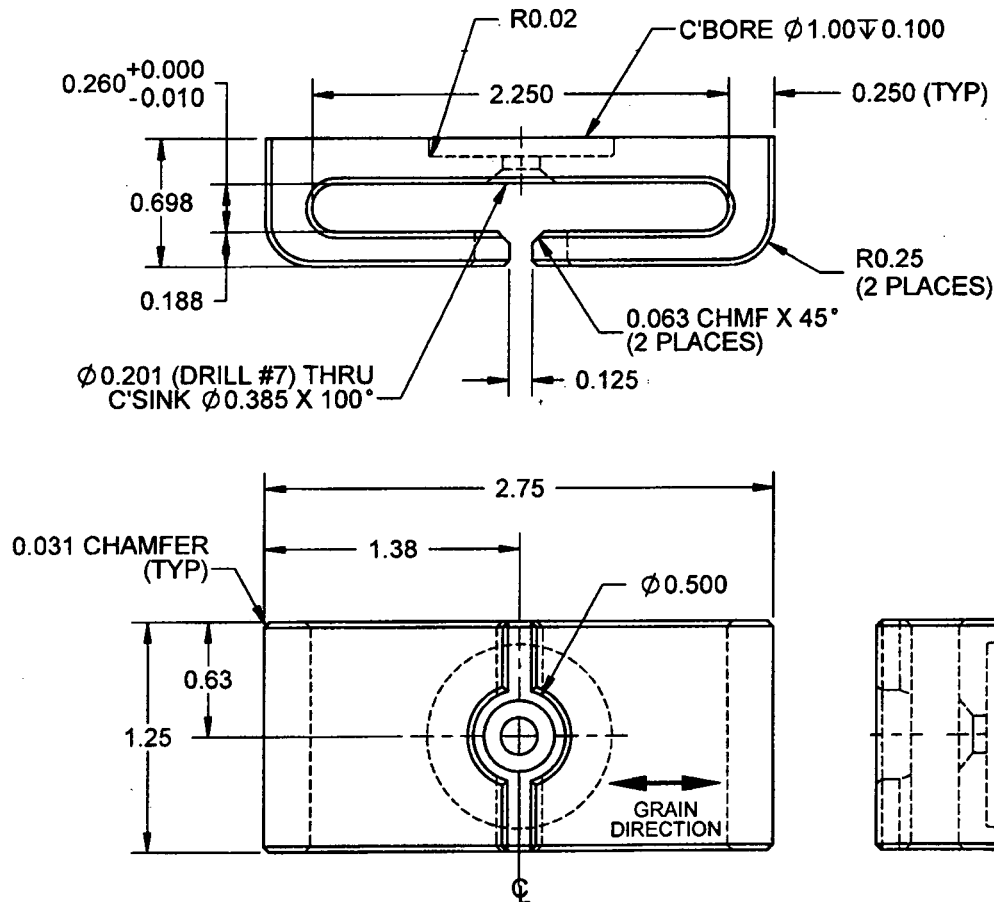
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DART

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571	REV. A SHEET 1 OF 2
DATE 07.01.29	TITLE GUIDE		SCALE 1:1
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE	

RELEASED07.04.12 *[Signature]*

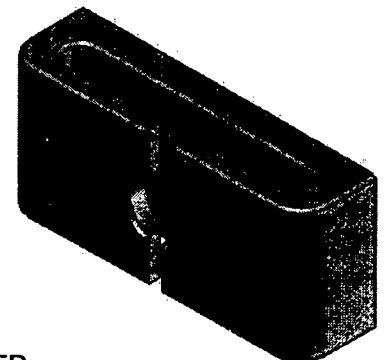
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO REWORK
WITHOUT NOTICE
WORK ORDER
NO. *62015*

*BF10-9-13***D3571-1 GUIDE****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ

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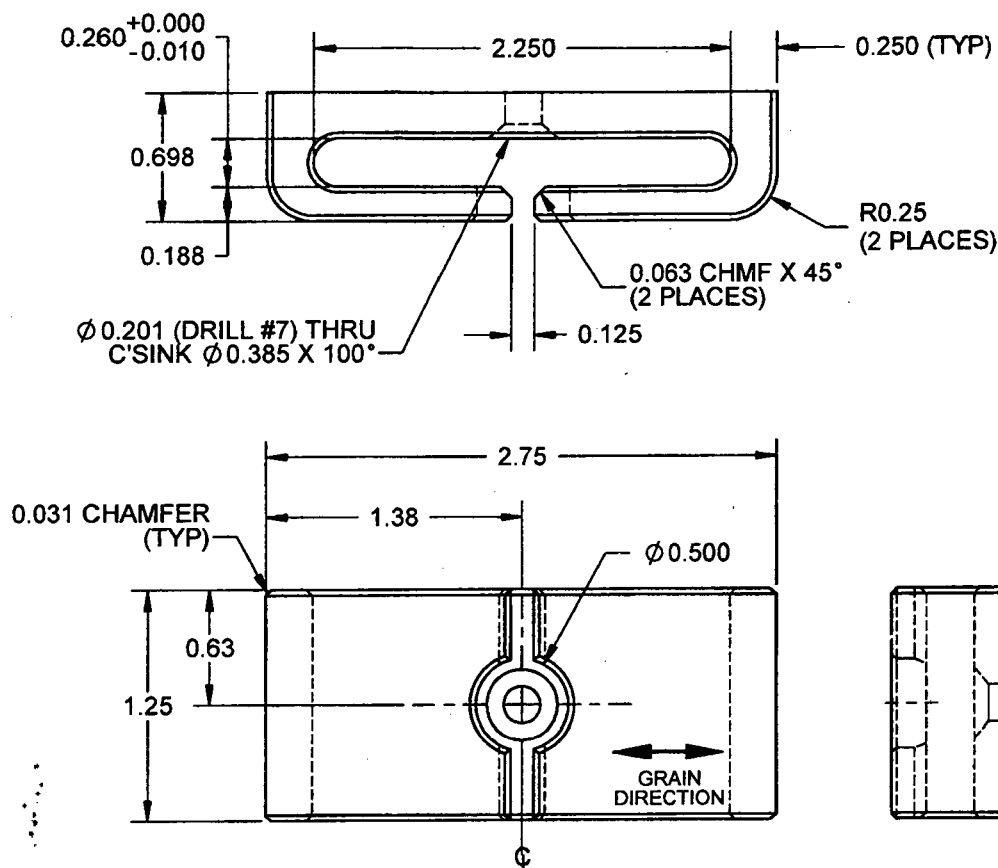
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571	REV. A
DATE 07.01.29		TITLE GUIDE	SHEET 2 OF 2 SCALE 1:1

RELEASED
07.04.12 *[Signature]*

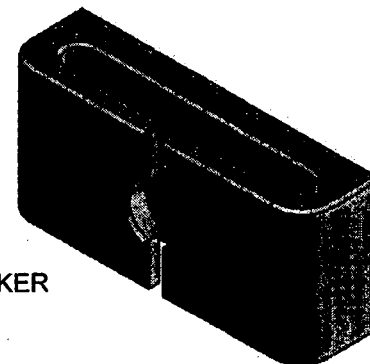
w/o 42015



D3571-3 GUIDE

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- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ



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